

## **Amendments to the Claims**

### **Listing of Claims:**

Claims 1-23 (canceled).

Claim 24 (new). A method of fastening a tool in a tool chuck, which comprises the steps of:

determining by measurement an actual position of the tool;

inserting the tool into the tool chuck;

positioning the tool in the tool chuck on a basis of the actual position previously determined;

shrink fitting the tool in place; and

determining an actual position of the tool in the tool chuck after the shrink fitting step.

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Claim 25 (new). The method according to claim 24, which further comprises monitoring the actual position of the tool during the inserting step for inserting the tool into the tool chuck.

Claim 26 (new). The method according to claim 24, which further comprises during the shrink fitting step, holding the tool with a tool gripper which also held the tool during the measurement.

Claim 27 (new). The method according to claim 24, which further comprises fastening the tool chuck in a spindle during the shrink fitting step and not removing the tool chuck from the spindle until after the actual position of the tool in the tool chuck has been determined.

Claim 28 (new). The method according to claim 24, which further comprises:

shrinking a number of tools in place in a respectively associated tool chuck;

depositing the tools with the tool chucks in a loading and unloading magazine;  
and

determining the actual position of the tools in the tool chucks.

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Claim 29 (new). The method according to claim 24, which further comprises positioning the tool in the tool chuck at a distance from a desired position corresponding to a correction size.

Claim 30 (new). The method according to claim 24, which further comprises writing the actual position to a data carrier connected to the tool chuck, after the actual position has been determined.

Claim 31 (new). The method according to claim 24, which further comprises determining a traverse path for moving the tool from the actual position determined into the tool chuck from the actual position.

Claim 32 (new). The method according to claim 24, which further comprises determining the actual position in a non-contact manner.

Claim 33 (new). The method according to claim 24, which further comprises determining the actual position in regards to an element of the tool selected from the group consisting of a cutting edge, a corner, an edge and a tip.

Claim 34 (new). The method according to claim 24, which further comprises defining the actual position of the tool with regard to a reference point on the tool chuck.

Claim 35 (new). The method according to claim 24, which further comprises rotating the tool, before a determination of the actual position, about a rotation axis outside the tool chuck in front of an optical measuring system.

Claim 36 (new). The method according to claim 24, which further comprises holding the tool with a tool gripper during the measurement.

Claim 37 (new). The method according to claim 36, which further comprises holding the tool, for the measurement, concentrically to a rotation axis of a spindle.

Claim 38 (new). The method according to claim 36, which further comprises using the tool gripper to rotate the tool about its rotation axis.

Claim 39 (new). The method according to claim 24, which further comprises determining the actual position in a radial direction relative to a tool axis after the shrink fitting step.

Claim 40 (new). The method according to claim 24, which further comprises detecting an unintentional movement of the tool during the inserting step.

Claim 41 (new). The method according to claim 24, which further comprises determining the actual position immediately after the shrink fitting step.

Claim 42 (new). The method according to claim 41, which further comprises comparing the actual position determined immediately after the shrink fitting step with a subsequently determined actual position after the tool chuck has cooled down.

Claim 43 (new). The method according to claim 24, which further comprises heating the tool chuck during the shrink fitting step and a temperature of the tool chuck is monitored by a sensor before the positioning of the tool.

Claim 44 (new). The method according to claim 24, which further comprises mounting the tool chuck in a spindle rotatable about a rotation axis.

Claim 45 (new). The method according to claim 28, which further comprises configuring the loading and unloading magazine to be rotatable about a rotation axis.

Claim 46 (new). The method according to claim 28, which further comprises positioning the tool in front of or in a cooling station by rotation of the loading and unloading magazine.

Claim 47 (new). The method according to claim 24, which further comprises determining the actual position of the tool in a direction of a longitudinal axis of the tool.